



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D2804-042
Job Sheet 175954



Part No: D2804-042

Job Qty: 4 ea

Part Name: RH Step Fwd Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

→ Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP Rev:G As per Rev C 06-11-08 JLM IPP
REV:H 16.06.23 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/19/18	0.00	0.00	Start Up Small Fab-1		
100	Small Fab	4 pcs		5/19/18	0.00	0.28	Small Fab-2		
110	QC	4 pcs		5/19/18	0.00	0.00	QC5		
120	Powdercoat	4 pcs		5/19/18	0.00	0.20	Powdercoat1		
130	QC	4 pcs		5/19/18	0.00	0.00	QC3		
150	Small Fab	4 pcs		5/21/18	0.00	0.28	Small Fab-2		
160	QC	4 pcs		5/21/18	0.00	0.00	QC5		
170	Packaging	4 pcs		5/21/18	0.00	0.00	Packaging3-1		
180	QC21-SA	4 Ea		5/21/18	0.00	0.00	QC21		

Part Op 100 - Press D2805-2 and D2809 into arm as per Dwg D2804

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 1:50 OVEN TEMPERATURE: 320°

FINISH TIME: 2:20 M 138760

130 - QC3- Inspect Part Finish

150 - 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2804-2	Bracket	4 Ea (1 ea)	90-Start up Operation	F163607
D2805-2	Stop	4 Ea (1 ea)	90-Start up Operation	F149476
D2809	Washer	4 Ea (1 ea)	90-Start up Operation	5072531
AN3C16A	Bolt	8 Ea (2 ea)	150-Small Fab	F1136648.80
D3672-15	Phenolic Washer	16 Ea (4 ea)	150-Small Fab	5042894
MS21043-3	Nut	8 Ea (2 ea)	150-Small Fab	5062620

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2804-2	4	8	0
	D2805-2	4	5	0
	D2809	4	12	0
	AN3C16A	8	48	0

D3672-15
MS21043-3

16
8

459
924

0
0

Part Specifications

Specifications could not be found.

Plex 4/12/18 12:52 PM Dart.lajeunesse.marie



Container No: S061583



Part: D2804-042

Job No: 175954

Serial No/Batch: S061583

Revision:

Inspector:

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Date: 04/17/18

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WORK ORDER

NO. 175954 M.C.S
1804-12

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

D2804-1
STA 155 BRACKET

9
AN3C16A BOLT
D3672-15 PHENOLIC WASHER, 2X
MS21043-3 NUT
2 PL

D2809
SPACER
8

D2804-2
STA 155 BRACKET

9
AN3C16A BOLT
D3672-15 PHENOLIC WASHER, 2X
MS21043-3 NUT
2 PL

D2804-041 BRACKET ASSY

D2809
SPACER
8

D2804-042 BRACKET ASSY

D2805-2
STOP
8

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDTEX" (4.3.5.6) OR "BLACK SANDTEX" (4.3.5.7) OR "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.37 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

RELEASED

2016 JUN 22
ECN 16-604

D	REVISE TO CURRENT FORMAT: D3672-15 WAS NAS1515H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-499. D6-3/4: 2.656 WAS 2.654 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED